

Split →

Work Order ID 62157-2

PRELIMINARY ISSUE

Monday, September 20, 2010 8:27:27 AM

Page 1

Item ID: D4134-041

Accept

Revision ID:

Item Name: Wearplate, LH Aft

Start Date: 9/17/2010 Start Qty: 2.00

Required Date: 9/24/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-9-20

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4134

pb1

100



Waterjet

FLOW CNC Waterjet

304.080

FLOW WATER JET

0.00

Memo

1-Cut D4134-1F as per Dwg D4134

Dwg Rev: pb1

Prog Rev: pb1

2-Deburr if necessary

SCRAP

Scrap

10-9-21

(3)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10-9-21

120



QC

Quality Control

QC8- Inspect parts - second check

0.00 - inspected to PB1

Dwg only

0.00

8/10/04/22

(X3)

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Page 2

Item ID: D4134-041

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Stop

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Run Start

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Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Form as per dwg
NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1- Form using DT _____ Die as per Dwg D4134

10.09.27 (3)

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

10.09.27 (2)

150

Weld per dwg A/R Hardcoat S.S. Batch: 1115553 0.00
Large Fab

Large Fab

Memo

0.00

Large Fab

Weld hard surface using DT _____ as per QSI 004 and Dwg D4134

10.09.28 (3)

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

h

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Stop



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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00 - inspected by PB1



QC

Memo

0.00

Dug only

8/10/09/25 (28)

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Bl 10-09-29

(3)

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Bl 10-09-29

(3)

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00
320°
8:30

Crk Order ID 62157

Monday, September 20, 2010 8:27:27 AM



Page 4

Item ID: D4134-041

Accept



Setup Start



Revision ID:

Item Name: Wearplate, LH Aft

Stop



Start Date: 9/17/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/24/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

=) 41 10/09/29

0.00

3

0

Memo

200



Small Fab

Small Fab

Memo

0.00

0.00

1- Bond D4134-3 gasket to inner surface of wearplate using a thin layer of 3M
1300/1300L scotch grip adhesive
Batch 4/15-230

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

W11.12.13

Work Order ID 62157

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Page 5

Item ID: D4134-041

Accept

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Item Name: Wearplate, LH Aft

Setup Start

Stop

Start Date: 9/17/2010 Start Qty: 2.00

Required Date: 9/24/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

Identify as per dwg & Stock Location: _____

0.00



Packaging

Packaging

Memo

0.00

Packaging

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Fast Print

Monday, September 20, 2010 8:27:31 AM

Page 1

Work Order ID: 62157

Parent Item: D4134-041

Parent Item Name: Wearplate, LH Aft



Start Date: 9/17/2010

Required Date: 9/24/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06 25 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA		Purchased	No			100	sf	148.0479	1.5825	3.165317			
-----------	--	-----------	----	--	--	-----	----	----------	--------	----------	--	--	--



304/316 .050 Sheet



1310-9-21

Location

Loc Qty

Loc Code

MAT20

148.0479

111743

7.36

112885

18.5179

113062

58.17

115389

64

D4134-3

Manufactured No

200

Each

0.0000

1

2.000200



Gasket



662160 (2)

DART AEROSPACE LTD		Work Order: 62157
Description: WEAR PLATE		Part Number: D4134-041
Inspection Dwg: D4134-1 Rev: pbl		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

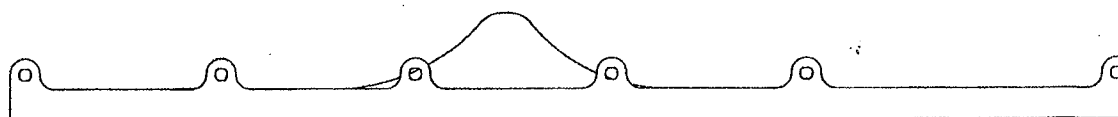
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .203	± .005 .001	.205	*		✓ 1B02	
.490	± .10	.485	*		✓	
.97	± .30	.963	*		✓	
2.89	± .30	2.886	*		✓	
4.80	± .30	4.794	*		✓	
5.280	± .10	5.279	*		✓	
5.77	± .30	5.765	*		✓	
8.05	± .30	8.200				OK 10/9/22
.375	± .010	.375	*		✓	
5.85	± .30	5.852	*		✓	
8.249	± .010	8.249	*		✓ PRO 02	
13.170	± .010	13.170	*		T 1B01	
15.85	± .030	15.85	*		T	
15.73	± .30	15.73	*		T	
15.98	± .30	15.98	*		T	
18.00	± .010	18.002	*		T	
23.013	± .010	23.013	*		T	
25.85	± .030	25.85	*		T	
27.934	± .010	27.934	*		T	
28.31	± .30	28.31	*		T	
.450	± .010	.452	*		✓	
.300	± .010	.303	*		✓	
.050	± .010	.047	*		✓	

Measured by: PB	Audited by: S	Prototype Approval: N/A
Date: 10-9-21	Date: 10/02/22	Date: N/A

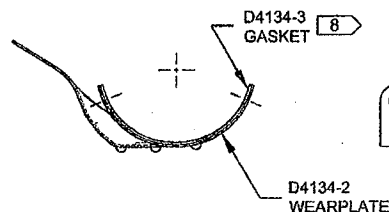
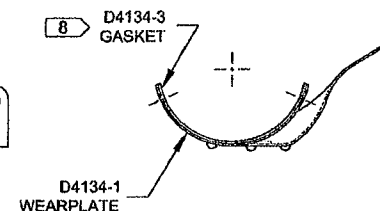
inspected by PBI Dwyer

Rev	Date	Change	Revised by	Approved
A	-	New Issue	KJ/JLM	

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X	X	D4134-041	WEARPLATE, LH AFT
		D4134-042	WEARPLATE, RH AFT
1		D4134-1	WEARPLATE
1	1	D4134-2	WEARPLATE
1	1	D4134-3	GASKET
A/R	A/R	1300 / 1300L	3M SCOTCH-GRIP ADHESIVE



D4134-041 WEARPLATE, LH AFT



D4134-042 WEARPLATE, RH AFT

PRELIMINARY ISSUE

CP 10.09.15

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4134-xxx" USING YELLOW PAINT MARKER ON INSIDE SURFACE
- 7) WEIGHT: -041/-042 = 2.2 lbs
- 8) BOND D4134-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

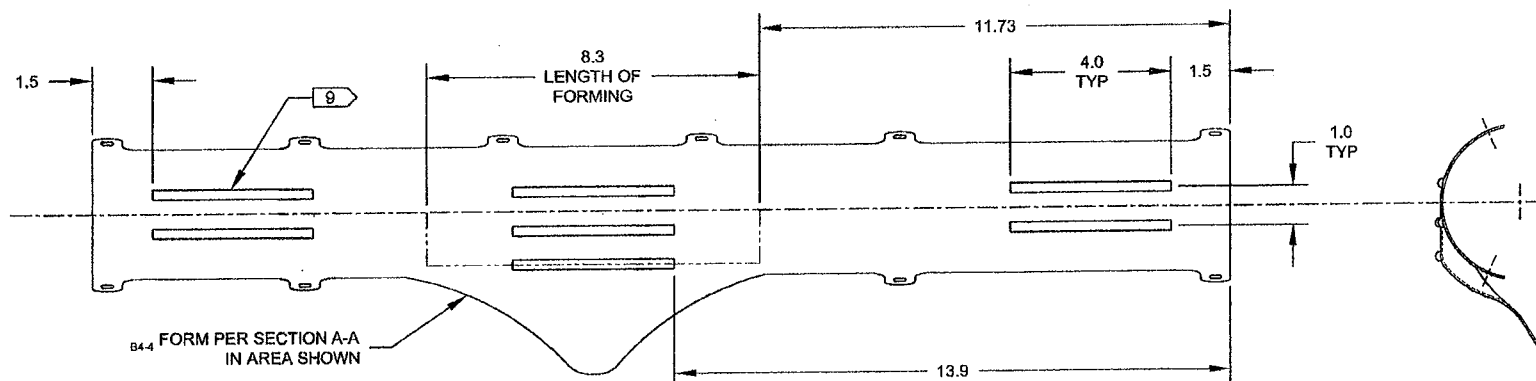
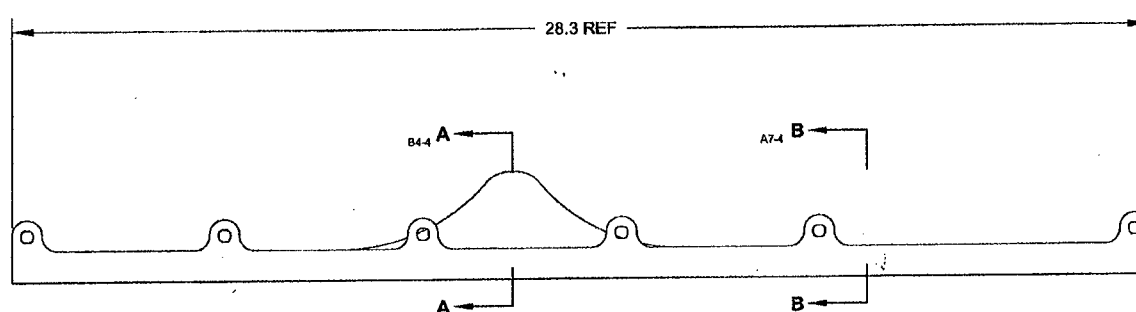
DESIGN	0.450 WAS 0.300	CP	10.09.15
DRAWN	A	NEW ISSUE	CP 10.08.15
CHECKED		DESCRIPTION	BY DATE
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.15		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D4134
SHEET 1 OF 6

TITLE WEARPLATE, AFT
SCALE NTS

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D4134-1 WEARPLATE, LH

PRELIMINARY ISSUE

10.09.15

NOTES:

- 1) MATERIAL: MAKE FROM D4134-1F
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) WELD PER QSI 004
- 9) 2059B HARDCOAT WELDS, 0.063 TO 0.125 HIGH

DESIGN	<i>DP</i>	DART AEROSPACE USA, INC	
DRAWN	<i>DP</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. <i>8</i>
MFG. APPR.		D4134	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE, AFT	NTS
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